

Date: Monday, 10/22/2007 3:42:01 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SUPPORT |
| Job Number | : 35287B | | |
| Estimate Number | : 10462 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D32782 |
| This Issue | : 10/22/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3278 REV. C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision | : C |
| Previous Run | : 35081B | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 11/10/2007 Qty: 40 Um: Each |
| Checked & Approved By | : <i>[Signature]</i> | | |
| Comment | : Est:A 04.04.19 New issue KJ/JLM | | |
| | Est B 07.09.06 Rev C dwg EC Verified by: JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B1000X02000 | 6061-T6 Bar 1.0" x 2.0" |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.2454 f(s)/Unit Total : 9.8154 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: *M105817**mk 07/11/06*

(40)

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

mk 07/11/06

(40)

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

mk 07/11/07

(40)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 07/11/07

(40)

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.F. 07/11/08

(40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 21/11/13
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:42:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 35287B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-11-08

(40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 1059/4

FL 07/11/12

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 07-11-12

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 55 80

40K AS 07/11/12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/13

Job Completion



U 07/11/13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 35287B |
| Description: Support | | Part Number: D3278-2 |
| Inspection Dwg: D3278 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | Ø0.099 | — | | | |
| 0.359 | +/-0.005 | 0.360 | — | | | |
| 0.609 | +/-0.010 | 0.609 | — | | | |
| 0.250 | +/-0.010 | 0.250 | — | | | |
| 1.480 | +/-0.005 | 1.480 | — | | | |
| R0.125 | +/-0.010 | R0.125 | — | | | |
| 0.119 | +0.005/-0.004 | 0.116 | — | | | |
| 2.439 | +/-0.010 | 2.441 | — | | | |
| 1.980 | +/-0.010 | 1.980 | — | | | |
| R0.13 | +/-0.030 | R0.130 | — | | | |
| Ø0.257 | +0.005/-0.000 | Ø0.260 | — | | | |
| R0.375 | +/-0.010 | R0.375 | — | | | |
| 0.875 | +/-0.010 | 0.875 | — | | | |
| 0.500 | +/-0.010 | 0.501 | — | | | |
| R0.400 | +/-0.010 | R0.400 | — | | | |
| R1.00 | +/-0.030 | R1.00 | — | | | |
| 1.720 | +/-0.010 | 1.723 | — | | | |
| R0.125 | +/-0.010 | R0.125 | — | | | |
| 0.125 | +/-0.010 | 0.126 | — | | | |

| | | | |
|--------------------------------|------------------------------|----------------------------|-----|
| Measured by: <i>gmk</i> | Audited by: <i>BE</i> | Prototype Approval: | N/A |
| Date: 07/11/07 | Date: 02.11.07 | Date: | N/A |

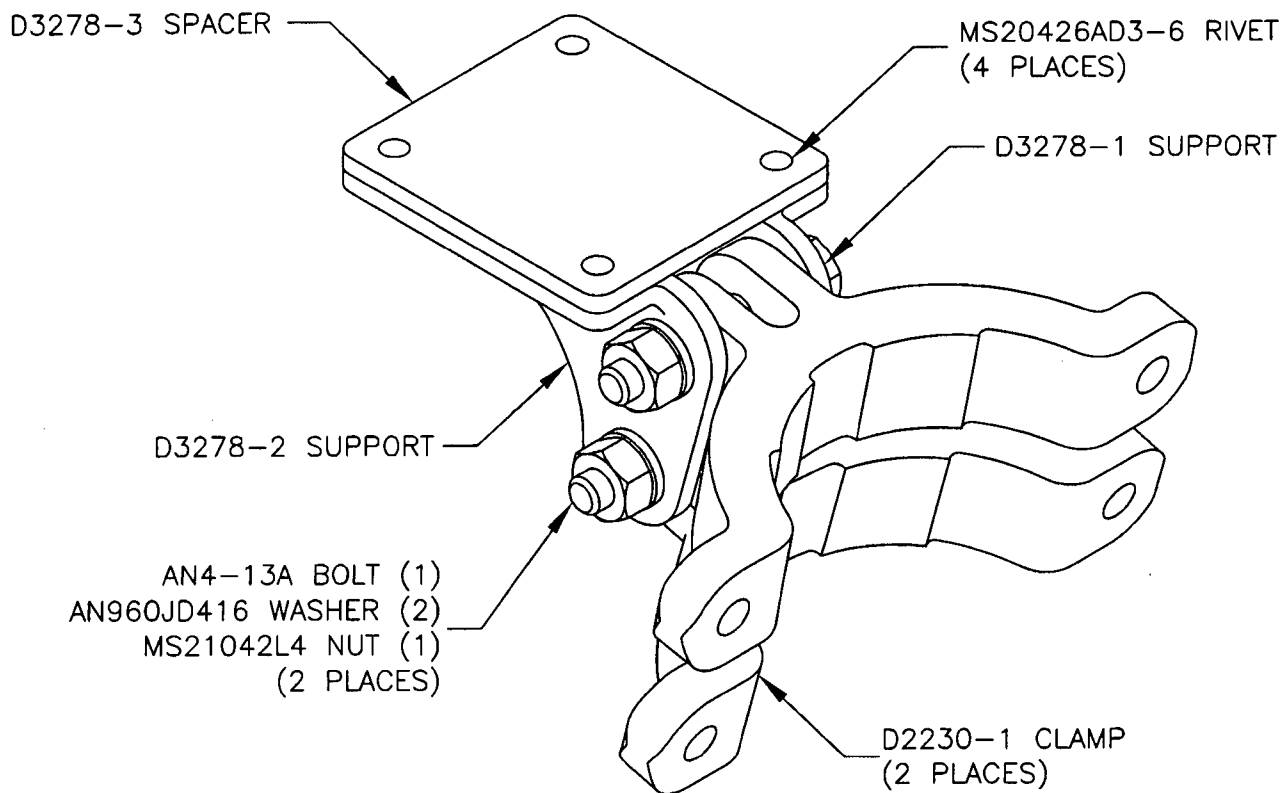
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|-----------------|-----------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM | |
| C | 07.09.26 | Dimensions updated per Dwg Rev. C | KJ/EC <i>AF</i> | <i>BE</i> |



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN 97 | DRAWN BY JC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED B | APPROVED H | DRAWING NO. D3278 | REV. C SHEET 1 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE NTS |
| A | 04.03.03 | NEW ISSUE | |
| B | 05.03.31 | CHANGE DIM/TOL TO ENSURE FIT | |
| C | 07.07.24 | CHANGED RIVETS PER PAR #185 | |

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



| Qty | Part Number | Description |
|-----|--------------|------------------|
| X | D3278-041 | SUPPORT ASSEMBLY |
| 2 | D2230-1 | CLAMP |
| 1 | D3278-1 | SUPPORT |
| 1 | D3278-2 | SUPPORT |
| 1 | D3278-3 | SPACER |
| 2 | AN4-13A | BOLT |
| 4 | AN960JD416 | WASHER |
| 4 | MS20426AD3-6 | RIVET |
| 2 | MS21042L4 | NUT |

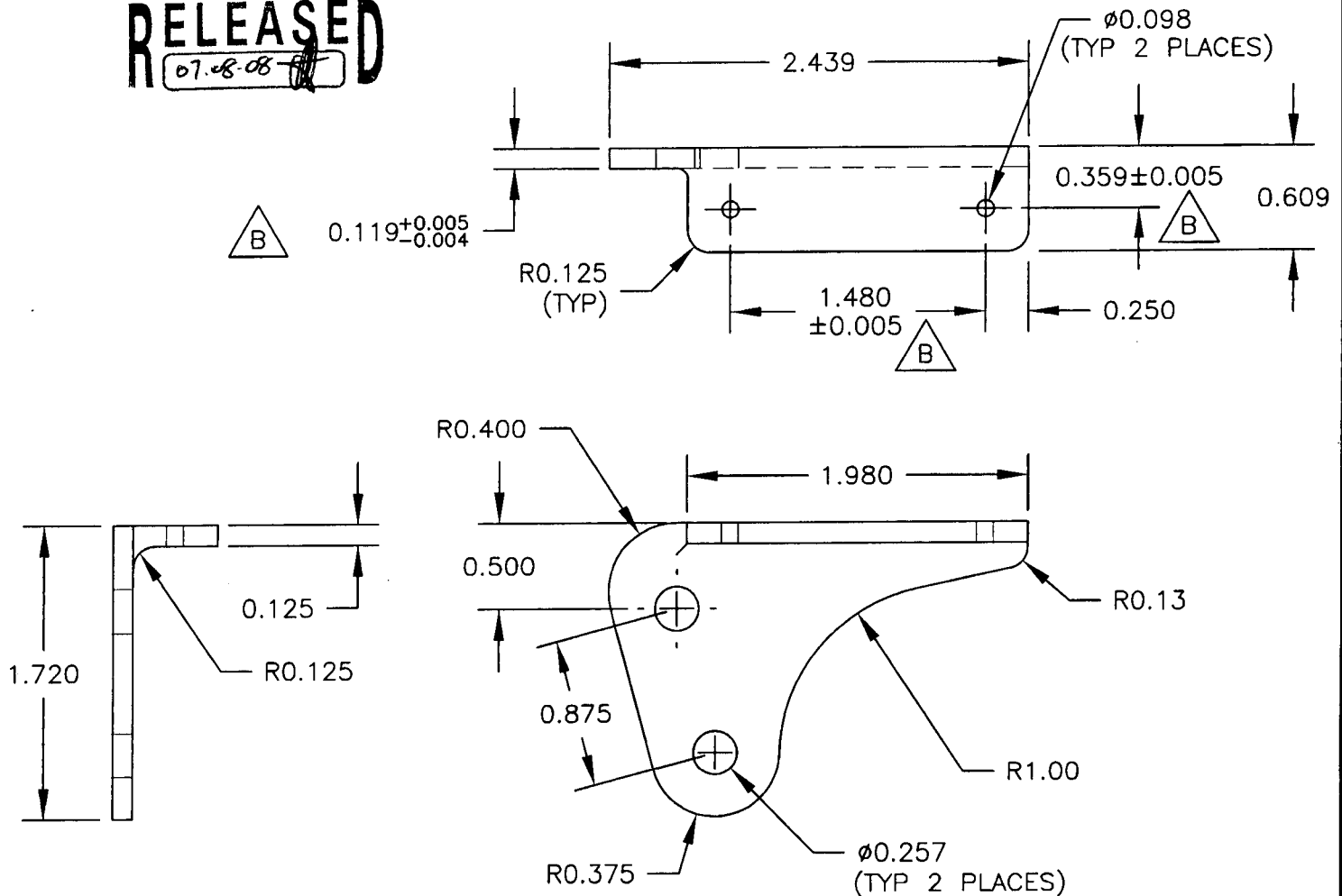
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| | | | |
|------------------------|---------------------------|---|------------------------|
| DESIGN 9P1 | DRAWN BY BC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3278 | REV. C SHEET 2 OF 3 |
| DATE 07.07.24 | TITLE SUPPORT ASSEMBLY | | SCALE 1:1 |

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPR1"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

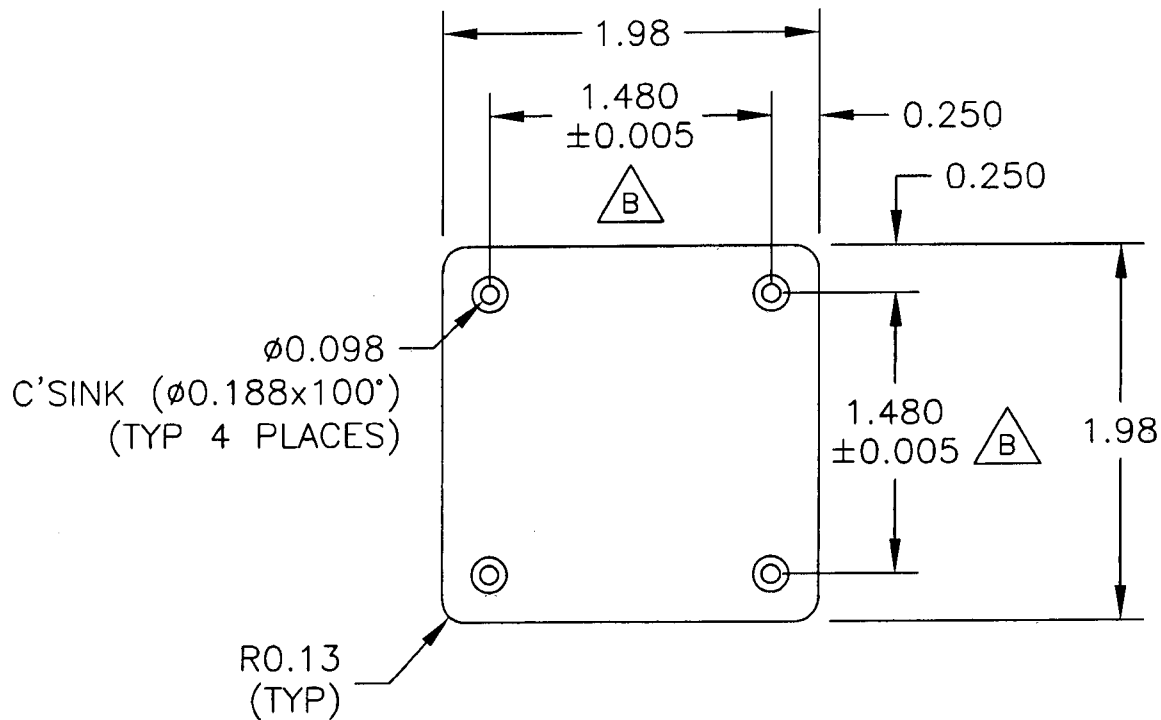
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| | | | |
|---------------------|--------------------------------|---|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>SC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>B</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3278 | REV. C SHEET 3 OF 3 |
| DATE 07.07.24 | TITLE SUPPORT ASSEMBLY | | SCALE 1:1 |

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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